

10,698,592  
54,19,04

## PRELIMINARY AMENDMENT

Please enter the following Preliminary Amendment:

In the Claims:

All of the claims are listed. Please amend second numbered claims 64-65 and claims 66-67 as follows:

1. (Original) A clamp for securing a work piece during a manufacturing operation, comprising:
  - a support arranged to at least partially surround a circumference defining a work area on the work piece, the support having a first end movable relative to a surface of the work piece; and
  - at least one friction reducing element attached to the first end and disposed between the support and the work piece, the friction reducing element adapted to at least partially surround the circumference and to apply a clamping pressure to the surface when the clamp is engaged with the work piece and moved across the work piece.
2. (Original) The clamp of Claim 1, wherein the support is adapted to substantially surround the circumference.
3. (Original) The clamp of Claim 1, wherein the work area includes a friction stir welding area.
4. (Original) The clamp of Claim 1, wherein the circumference surrounds and is larger than a diameter of a friction stir welding tool.
5. (Original) The clamp of Claim 1, wherein the support includes a cylinder.
6. (Original) The clamp of Claim 1, wherein the friction reducing element includes a lubricant.
7. (Original) The clamp of Claim 1, wherein the friction reducing element includes a low friction material.